



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBWA353A04
Job Sheet 172312



002722

Part No: RBWA353A04

Job Qty: 4 ea **2**

Part Name: Pmc Oil Filling Quick Disconnect



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/15/18

Job Tracking No:

Due Date: 2/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBWA353A04 Rev 4 IPP Rev A 18.02.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		2/27/18	0.00	0.00	Start Up Small Fab-2		MU
110	Small Fab	4 pcs		2/28/18	0.00	4.00	Small Fab-3		MU DAS
120	QC	4 pcs		2/28/18	0.00	0.00	QC5		38
130	Packaging	4 pcs		2/28/18	0.00	0.00	Packaging3-1		9-88
140	QC21-SA	4 Ea		2/28/18	0.00	0.00	QC21		DAS 21 9-88

Part Op 110 - 1-Assemble as per DWG. Sheet . 2-Engrave 1632T22 tag using marktronic engraver as per DWG. 3-Fabricate 2018
Descriptions: attach lanyard as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
1632T22	Aluminum Tag 1" X 2" X 0.04"	4 pcs (1 ea)	90-Start up Operation	1138507
2619	Spring Rnd 3/4" (Century Spring)	4 (1 ea)	90-Start up Operation	5057045
3896T31	Ferule 1/16 X 3/8" - Aluminum	8 Ea (2 ea)	90-Start up Operation	
50715K179	Female Pipe Adapter SS	4 Ea (1 ea)	90-Start up Operation	5059850
91665A350	Retaining Ring, 7/16" Shaft	4 Ea (1 ea)	90-Start up Operation	5041069
9262K613	O-Ring 13mm OD x 1mm	4 Ea (1 ea)	90-Start up Operation	
CL-2-C	Lanyard Wire	1.6800 ft (.42 ea)	90-Start up Operation	
RBWA353A04-01	Cap OK	4 Ea (1 ea)	90-Start up Operation	5061607
RBWA353A04-02	Sleeve OK	4 Ea (1 ea)	90-Start up Operation	5059015
RBWA353A04-03	Barb 137	4 Ea (1 ea)	90-Start up Operation	5061009
RBWA353A04-05	Quill OK	4 Ea (1 ea)	90-Start up Operation	5062507
RBWA353A04-06	Cap OK	4 Ea (1 ea)	90-Start up Operation	5061857
RBWA353A04-07	Valve OK	4 Ea (1 ea)	90-Start up Operation	5062268
RBWA353A04-08	Screw (Modified B/O) 2A093	8 Ea (2 ea)	90-Start up Operation	5057254 & 5057743 3x
S1030	Spring .025 Wire: .300 O.D X .5 free length	4 (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	1632T22	4	98	0
	2619	4	0	0
	3896T31	8	604	0
	50715K179	4	0	0
	91665A350	4	0	0
	9262K613	4	0	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		Date : _____ Step #: _____ <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 10%; text-align: center;">at</td> <td style="width: 10%; text-align: center;">☐</td> <td style="width: 10%; text-align: center;">Engineering</td> <td style="width: 10%; text-align: center;">☐</td> </tr> <tr> <td style="text-align: center;">r.</td> <td style="text-align: center;">☐</td> <td style="text-align: center;">Quality</td> <td style="text-align: center;">☐</td> </tr> <tr> <td style="text-align: center;">g</td> <td style="text-align: center;">☐</td> <td style="text-align: center;">Other</td> <td style="text-align: center;">☐</td> </tr> <tr> <td style="text-align: center;">r</td> <td style="text-align: center;">☐</td> <td></td> <td style="text-align: center;">☐</td> </tr> </table> MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval 		at	☐	Engineering	☐	r.	☐	Quality	☐	g	☐	Other	☐	r	☐		☐
at	☐	Engineering	☐																		
r.	☐	Quality	☐																		
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r	☐		☐																		
Description Work Order Deviation																					
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		OTHER : _____																			

Date: 04/26/18
 Inspector: _____
 Revision: 4
 Serial No/Batch: S065418
 Job No: 172312
 Part: RBWA353A04
 Container No: S065418
DART AEROSPACE
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

CL-2-C	2	503	0
RBWA353A04-01	4	0	0
RBWA353A04-02	4	0	0
RBWA353A04-03	4	0	0
RBWA353A04-05	4	0	0
RBWA353A04-06	4	0	0
RBWA353A04-07	4	0	0
RBWA353A04-08	8	0	0
S1030	4	0	0

Part Specifications

Specifications could not be found.

Plex 2/15/18 10:18 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

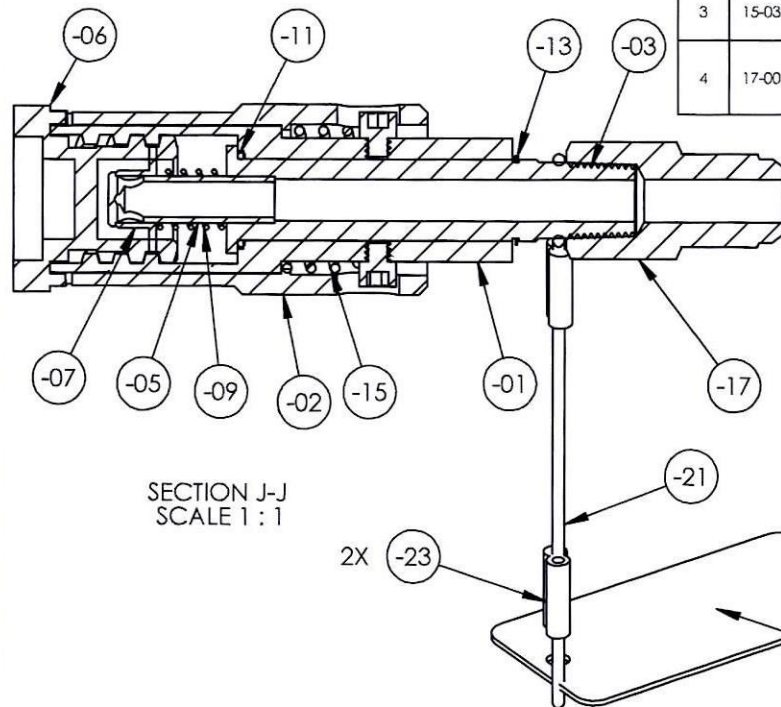
QA Closed: _____ Date: _____

Work Order update only ☐

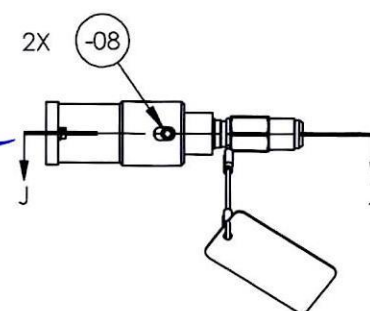
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		REDESIGNED ASSEMBLY	2/22/2011	JAG	
2		DELETED -19, -21, & -23 CH'D -15 FROM HOSE & -17 FROM HOSE CLAMP, ADDED -19, -21, & -23. -01 CH'D TO CLEAR ANODIZE, -02 CH'D TO CLEAR ANODIZE, CH'D -03 THRU HOLE FROM Ø.17, CH'D DESIGN ADDED 1/8 NPT -27 FOR FITTING, CH'D -05 ID FROM Ø.14 & CH'D LIMIT DIMENSION FROM Ø.2510-.2514 S.F. -07, CH'D -07 ID LIMIT DIM. FROM Ø.2515-.2520 & S.F. -05 PER D.W.	1/17/2012	RJC	DW
2A		-03 REMOVED X.50 DEPTH FROM 1/8 NPT	1/3/2013	BIM	GE
3	15-0335	-01 DIM WAS Ø.675 IS Ø.665 TO ACCOMODATE NEW -15 SPRING, -02 CH'D DIM'S WAS 2X Ø.800 IS Ø.800, ADDED DIM Ø.810 FOR NEW SPRING, CH'D ENGRAVE NOTE WAS ENGRAVE T/N TO FIT IS ENGRAVE T/N, S/N, MADE IN USA, -15 CH'D P/N WAS CENTURY SPRING #B15-66 IS 2619.	10/13/2015	RJC	JAG
4	17-0070	UPDATED TO NEW STANDARDS, -01 CH'D FLANK OF THREAD START WAS ON CENTERLINE, IS 5° OFFSET FROM CENTER LINE, WAS 17° IS (16°); WAS (.10) IS (.08); WAS .101 IS .100, -03 CH'D DIM WAS 2X Ø .438 IS 2XØ.4374/.4354, -05 CH'D DIM WAS Ø.2515/.2510 S.F. -07 IS Ø.2515/.2510 (S.F. -07), -06 ADDED, -07 CH'D DIM WAS Ø.2530/.2520 S.F. -05 IS Ø.2530/.2520 (S.F. -05).	3/21/2017	SM	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172312
MCS
1802-15



"NOT TO BE USED FOR HIGH
PRESSURE APPLICATION"
"100 PSI MAX"

B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	-01	1	CAP	6061		2
	-02	1	SLEEVE	6061		3
	-03	1	BARB	303/304 S.S.		4
	-05	1	QUILL	303/304 S.S.		5
	-06	1	CAP	6061		6
	-07	1	VALVE	303/304 S.S.		7
	-08	2	SCREW	S.S.	6-32 X 1/8 (MCMASTER-CARR #92196A139) MODIFIED	8
B/O	-09	1	SPRING	MUSIC WIRE	Ø.025 WIRE: Ø.300 OD X .5 FREE LENGTH (RIED #S1030)	1
B/O	-11	1	O-RING	BURNA-N	Ø13mm OD X 1mm (MCMASTER-CARR #9262K613)	1
B/O	-13	1	EXTERNAL RETAINING RING	SPRING STEEL	Ø7/16 SHAFT (MCMASTER-CARR #91665A350)	1
B/O	-15	1	SPRING	SPRING STEEL	Ø.78 (CENTURY SPRING #2619)	1
B/O	-17	1	FEMALE PIPE ADAPTER	S.S.	MCMASTER-CARR #50715K179	1
	-19	1	TAG	ALUMINUM	1/32 X 1 X 2	1
B/O	-21	1	LANYARD	COATED GALV. STEEL	(7X7 CABLE) Ø1/16 X 5in. (CARR LANE #CL-2-2)	1
B/O	-23	2	FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMASTER-CARR #3896T31)	1



TITLE
PMC OIL FILLING QUICK DISCONNECT

DWG NO. RBWA353A04 REV 4

MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: DD 03/22/2017	.015 x 45° OR .015R
OPPS APPR: AA 03/28/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 03/29/2017	AFTER PLATING
APPROVED: JAG 04/03/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:3	USED ON MODEL
DATE 2/22/2011	AGUSTA HELICOPTERS
SHEET 1 OF 8	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					